

46502

DART AEROSPACE LTD	Work Order:	21771
Description: Inner Aft Saddle	Part Number:	D5957
Drawing: D5957 Rev. A	Qty:	6

03.05.16

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required</i>	<i>HA</i>	04.10.22	6
2	STORES	Issue material from stock: D6101-007 (7075-T7351) Cut Size 2.50" x 7.50" X 8.25" (Grain along 7.50") Batch: <i>21802</i>	<i>J.L</i>	05/05/07	6
3	HAAS	Setup W/O No. <i>N/A</i> Setup Inspection last completed <i>05/05/06</i> by <i>ISG</i>	<i>ISG</i>	05/05/06	6
4	HAAS	Machine as per folio D5957 Ensure Batch Number is entered	<i>J.L</i>	05/05/07	6
5	HAAS	Deburr and Tumble	<i>J.L</i>	05/05/07	6
6	QC	Inspect Level 1 Fill Out Inspection Sheet	<i>J.L</i>	05/05/07	6
7	QC	Inspect Level 8 Audit Inspection Sheet	<i>FF</i>	05.05.07	6
8	METAL	Acid etch and alodine as per QSI 005 4.1	<i>FF</i>	05/5/11	6
9	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	<i>MA</i>	05 05 12	6
10	QC	Inspect Level 3	<i>CL</i>	05/05/17	6
11	STORES	Pack in foam, identify and stock	<i>CL</i>	05/05/17	6
12	EXPEDITING	Close Work Order Cost / Part: <i>151.04</i> <i>5.05.05/18</i> <i>(6)</i>	<i>HA</i>	05.05.24	6

Rev	Date	Change	Revised By	Approved
A	97.03.05			
B	99.04.19	Re-format	DM	
C	00.06.22	Removed P/O for powder coat	EC	
D	02.02.06	Added D part # and inspect level 21	NG	

RELEASED
02/02/06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	21771
Description: Inner Aft Saddle	Part Number:	D5957
Inspection Dwg: D5957 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5957 Rev. A and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	/	/	/	/		
B	1.745	1.755		1.749	1.749	1.750	1.749		
C	5.245	5.255		5.249	5.250	5.249	5.249		
D	6.995	7.005		6.999	7.000	7.000	6.998		
E	5.745	5.755		5.748	5.750	5.749	5.750		
F	4.745	4.755		4.749	4.780	4.749	4.749		
G	0.313	0.318	DT8686	/	/	/	/		
H	1.522	1.532		1.526	1.528	1.527	1.527		
I	3.048	3.058		3.054	3.053	3.054	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.581		
K	0.313	0.318	DT8686	/	/	/	/		
L	0.240	0.260		-.250	-.251	-.250	-.250		
M	0.490	0.510		-.505	-.506	-.506	-.506		
N	0.240	0.260		-.250	-.251	-.250	-.250		
O	7.990	8.010		8.003	8.004	8.004	8.004		
P	0.240	0.260		-.254	-.253	-.251	-.250		
Q	0.307	0.312		-.312	-.312	-.311	-.312		
R	0.760	0.765		-.761	-.761	-.761	-.761		
S	0.490	0.510		-.500	-.500	-.501	-.500		
T	1.625	1.645		1.633	1.633	1.630	1.633		
U	2.000	2.020	DT8696 A/B	/	/	/	/		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L
Date:	05/05/07

Audited by:	EC
Date:	05 05.07

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	

RELEASED
03.06.18

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B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.249				
D	6.995	7.005		7.000	7.000				
E	5.745	5.755		5.751	5.750				
F	4.745	4.755		4.750	4.749				
G	0.313	0.318	DT8686	/	/				
H	1.522	1.532		1.527	1.527				
I	3.048	3.058		3.054	3.053				
J	4.575	4.585		4.580	4.580				
K	0.313	0.318	DT8686	/	/				
L	0.240	0.260		.250	.250				
M	0.490	0.510		.505	.505				
N	0.240	0.260		.251	.251				
O	7.990	8.010		8.004	8.004				
P	0.240	0.260		.253	.250				
Q	0.307	0.312		.312	.311				
R	0.760	0.765		.761	.761				
S	0.490	0.510		.501	.501				
T	1.625	1.645		1.633	1.633				
U	2.000	2.020	DT8696 A/B	/	/				
V									
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RELEASED
03.06.18

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 21, 2004
08:51 am

Work Order No : 0021771
Project Name : D5957
Project For : WK446
Work Order Type : Main
Main WO Number :
House Part Number : D5957
Description : Saddle
Manufactured : Yes
Amount Req'd : 6
Amount Done : 0
Start Date : 10-20-04
Est Finish Date : 11-11-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00